

48851

Work Order ID 45711

July 14, 2009 7:26:25 AM



Item ID: D350-600-241

Accept



Setup Start



Revision ID: C

Item Name: Spacepod, LH, AS350

Stop



Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: mw

Date: 5/7/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-600-241
CHG 001

8 or 10/06

110

0.00



Small Fab

Memo

0.00

Small Fab

1-Drill holes in D3188-1 using drill jig Dt8970
2-Open holes in D3188-1 body floor to 0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-1 as per dwg D3188

~~ET 09-09-20~~

ET 09-09-30

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8 or 10/21

8 or 10/21

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item Name: Spacepod, LH, AS350

Start Date: 7/15/09 Start Qty: 1.00



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Required Date: 7/28/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Memo

0.00

1-Cut D2986 Neoprene Foam per template D2986T1

Small Fab

140

0.00



Small Fab

Memo

0.00

*** this step seperates hardware, previous steps is for baody & floor***

Small Fab

N/A cut on waterjet

as per
B# 48237

RT 09-10-07

N/A

RT 09-10-07
Ref step#130

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600
Hardware on previous steps is for door ass'y

1-drill and plug section I-I and J-J of dwg D3188 p. 11 using Hysol 934NA with
milled glass fibres 10% to weight

A/R Hysol batch: H0970 112099 exp 10-06-19

xpiry date: Dec 04 09

A/R Milled fibers batch: 100859 100859

2-Attach Neoprene Foam using Contact cement

A/R Contact cement Batch: 112225

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

⇒ Serial 101

Serial 101



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Required Date: 7/28/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170

Wing Walk as per dwg QSI005 4.4 Batch ~~111103~~ 0.00



HandFinish

Memo

Batch: m112106

0.00

UMD 09/10/02

ⓧ
XI

Hand Finishing

180

QC3- Inspect Part Finish



QC

Memo

0.00

0.00

~~BR 09-07-21~~
NR 09-10-2

ⓧ
ⓧ

Quality Control

190

QC4- 100% Inspect kits for completeness



QC

Memo

0.00

0.00

2) 501/10/06

ⓧ

Quality Control

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-600-141 Location: _____ PPP rev: <u>B</u>								
210	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Per 14/01

09/10/06

RD 09-10-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 1

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Parent Item Name: Spacepod, LH, AS350

Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3188-1MRevE		Manufactured	No			110	Each	0.0000	1.0000	48151A	ET 09.09.25	
SPACEPOD BODY LH										45711A	ET 9/1/09	
D3186-3RevD		Manufactured	No			110	Each	0.0000	1.0000	48151B01	ET 09.09.25	
Spacepod Door, LH										45711B	ET 9/1/09	
D3187-1RevC		Manufactured	No			110	Each	12.0000	1.0000			
Spacepod Floor												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 12
31835 1
37196 11

31835 SP

ALS4-1032-130 Purchased No

110 Each 7,749.000 28.0000

Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 7749
110511 7749

110511 9-9-23 @28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 2

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Parent Item Name: Spacepod, LH, AS350

Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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A3235-020-935

Purchased

No

110

Each

815.0000

8.0000



Washer - Countersunk

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

815

104156

59

106150

756

D2986-1RevB

Manufactured

No

130

Each

6.0000

1.0500



Rubber Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

48237

6

D3015-3RevB

Manufactured

No

140

Each

435.0000

1.0000



Locknut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

435

43758

26

44446

50

48238

359

106150 SP

48237 SP

48238 7/19/09 @ SP

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 45711

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Parent Item Name: Spacepod, LH, AS350



Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3554-7RevA		Manufactured	No			140	Each	81.0000	1.0000			
												
Ball Stud												

37674 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

81

37674

81

D3567-1RevA

Manufactured

No

140

Each

29.0000

1.0000



Decal

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

29

37311

9

48254

20

37311

9/9/23 QSP

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

Work Order ID: 45711

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350

Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			140	Each	1,548.000	1.0000			



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1548	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	241	
112082	1000	

111279 SP

D2237RevD1

Manufactured No

140

Each

30.0000

2.0000



Striker Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	30	
46162	30	

B50348 SP

46162 9/19/23 DS

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

Work Order ID: 45711

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350



Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-5		Purchased	No			140	Each	7,958.000	4.0000			
												B 6733 81 09-09-30
Rivet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 7958

4067 1141

6733 1835

6874 4982

~~4067~~ SP

D3538-1RevA

Manufactured No

140 Each 40.0000 2.0000



Hinge Bracket



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 40

44650 9

46753 12

48197 19

44650 9-9-23 RSP

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Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Spacepod, LH, AS350



Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2179RevB		Manufactured	No			140	Each	95.0000	2.0000			
												
Doubler												

35432 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 95

30630 1

35432 94

AN526C832R24

Purchased

No

140

Each

144.0000

4.0000



screw



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 144

104603 44

110179 100

104603 9-9-23 @SP

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Required Date: 7/28/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8		Purchased	No			140	Each	969.0000	4.0000			



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 969

107091 9

108335 11

110382 48

110917 3

111578 898

MS21042L08

Purchased

No

140

Each

222.0000

4.0000



Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 222

110002 24

111889 198

111578 50

M112492

9/9/23 @8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-08-11		Purchased	No			150	Each	139.0000	2.0000			
												
Screw												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 139

104427 6

108335 33

111977 100

AN960JD8

Purchased

No

150

Each

969.0000

16.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 969

107091 9

108335 11

110382 48

110917 3

111578 898

111977 SP

111578 9-9-23 @SP

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Parent Item Name: Spacepod, LH, AS350


Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3  Washer		Purchased	No			150	Each	530.0000	2.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	530	
109268	261	
110397	108	
111268	161	

111268 SP


MS21042L08  Nut		Purchased	No			150	Each	222.0000	14.0000			
---	--	-----------	----	--	--	-----	------	----------	---------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	222	
110002	24	
111889	198	

111268 SP
1112492 SP

D2464RevB  3/4 Seal		Manufactured	No			150	f	896.4300	11.3400			
---	--	--------------	----	--	--	-----	---	----------	---------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	896.43	
39669	112.58	
48173	783.85	

SP 02 01 01

11.34

July 14, 2009 7:26:24 AM

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W/O:		WORK ORDER CHANGES					
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Parent Item Name: Spacepod, LH, AS350


Comments:

Start Date: 7/15/09

Required Date: 7/28/09


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3567-1RevA 		Manufactured	No			150	Each	29.0000	1.0000			
Decal												


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	29	
37311	9	
48254	20	

37311 SP

D2586RevD 		Manufactured	No			150	Each	72.0000	2.0000			
Door Latch												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	72	
23082	0	
45554	1	
47183	71	

47183 SP

D2585RevB 		Manufactured	No			150	Each	22.0000	2.0000			
Mounting Channel												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	22	
45888	22	

B50544 SP

~~45888~~

9/9/23 DS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 7:26:24 AM

Work Order ID: 45711



Parent Item: D350-600-241RevC



Parent Item Name: Spacepod, LH, AS350

Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2621RevB		Manufactured	No			150	Each	91.0000	2.0000			

Latch Plate, 350 Spacepod

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

91

41175

5

46842

86

46842 50

MS27039-1-15

Purchased

No

150

Each

108.0000

2.0000



Screw

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

108

106903

3

108169

4

109321

4

111916

97

111916

9-9-23 @ SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 7:26:24 AM

Work Order ID: 45711



Parent Item: D350-600-241RevC



Parent Item Name: Spacepod, LH, AS350

Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 Washer		Purchased	No			150	Each	1,213.000	2.0000			

M112369 SC

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1213
105442	95
109059	2
109840	23
110985	202
111279	13
111668	878

MS21042L3

Purchased

No

150

Each

1,795.000 2.0000



Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1795
110844	34
111274	761
111668	1000

111274 SC

9/9/23 DSC

July 14, 2009 7:26:24 AM

Shop Packet Print

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 7:26:24 AM

Work Order ID: 45711

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350


Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2857-1RevB  Hinge Bracket		Manufactured	No			150	Each	30.0000	1.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 30

41166 7

45788 23

45788 SP

D2857-2RevB

Manufactured No

150

Each

38.0000

1.0000



Hinge Bracket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 38

43363 12

45797 26

45797 SP

D2228RevB

Manufactured No

150

Each

120.0000

4.0000



Bracket Plate

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 120

30679 73

48228 47

30679

9/9/23 (10) SP

July 14, 2009 7:26:24 AM

Shop Packet Print

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 14

Work Order ID: 45711

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350


Start Date: 7/15/09

Required Date: 7/28/09

Comments:


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R10 		Purchased	No			150	Each	195.0000	10.0000			
Screw												


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	195	
104603	195	

104603 SP

D3557-1RevA 		Manufactured	No			150	Each	18.0000	1.0000			
Bracket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
32647	7	
46887	11	

32647 SP

AN526C832R14 		Purchased	No			150	Each	1,051.000	2.0000			
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1051	
104916	1051	

9-9-23 (1x)
104916 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 7:26:24 AM

Work Order ID: 45711

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350

Comments:

Start Date: 7/15/09

Required Date: 7/28/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

K10021RevN/A

Manufactured

No

190

Each

5.0000

1.0000



Spacepod Hardware Kit (-241)

B50276 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

5

41361

2

47217

2

48266

1

D350-600-449RevC

Manufactured

No

190

Each

7.0000

1.0000



Switch Relocation

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

7

41358

4

47203

3

47203 SP

D2985RevA1

Manufactured

No

190

Each

19.0000

1.0000



Label

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

41341

4

48236

15

48236 9-9-23 SP

July 14, 2009 7:26:24 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 45711

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350

Comments:

Start Date: 7/15/09

Required Date: 7/28/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3547-1RevA

Manufactured

No

190

Each

20.0000

1.0000



Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

35455

20

3545550

D3550-1RevB

Manufactured

No

190

Each

31.0000

1.0000



Strut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

31

36226

5

45570

6

48367

20

48367 SP

D3552-7RevD

Manufactured

No

190

Each

16.0000

1.0000



Door Prop

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

32644

16

32644 9-9-23 1050

July 14, 2009 7:26:24 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 7:26:24 AM

Work Order ID: 45711



Parent Item: D350-600-241RevC



Parent Item Name: Spacepod, LH, AS350


Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3554-7RevA  Ball Stud		Manufactured	No			190	Each	81.0000	1.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

81

37674

81

190

Each

1,548.000

2.0000

37674 SP

AN960JD516

Purchased

No



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1548

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

241

112082

1000

111279

9-9-23 @ SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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July 14, 2009 7:26:24 AM

Work Order ID: 45711



Parent Item: D350-600-241RevC



Parent Item Name: Spacepod, LH, AS350

Start Date: 7/15/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3015-3RevB		Manufactured	No			190	Each	435.0000	1.0000			

Locknut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	435	
43758	26	
44446	50	
48238	359	

48238 9-9-23 RSP

July 14, 2009 7:26:24 AM

Shop Packet Print

Page 18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Material Requisitions

Part Number: MS20426AD4-5

Batch Number: 6733

R/S#: _____

Quantity: 4

Required by: AT Date: 09-09-30

Used for

Part Number: D350-600-241

Batch Number: 415711

Approved by Purchaser: _____

Date: _____

Comments:

TA TRANSQAMATERIAL REQ-A.DOC

Date: Tuesday, 10/02/2009 3:08:24 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD ASSEMBLY LH/ DSI 9335
Job Number : 45711	
Estimate Number : 12775	
P.O. Number :	Part Number : D350600241
This Issue : 10/02/2009 S.O. No. :	Drawing Number : IIN REV.C PG11,18-21
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 41283	Material :
Written By :	Due Date : 05/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09.02.10</u>	
Comment : Est Rev:A 07.03.07 new issue ec	
est rev B 07.04.16 reformat,D3188 revE ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0 ☒ DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-241 CHG001

2.0 ☒ 45711A

SPACEPOD BODY LH

**Comment:** Sub-Component SPACEPOD BODY LH

1 x D3188-1M Batch _____

3.0 ☒ 45711B

SPACEPOD DOOR LH

**Comment:** Sub-Component SPACEPOD DOOR LH

1 x D3186-3 Batch _____

4.0 ☒ D31871

Spacepod Floor

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-1

Floor _____

5.0 ☒ ALS41032130

Insert

**Comment:** Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:08:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 45711

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER

7.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Drill holes in D3188-1 using drill jig DT8970
2-Open holes in D3188-1 body floor to Ø0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-1 as per Dwg D3188.

8.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0



D2986

Black Neoprene Foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)
neoprene foam
batch: _____

10.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

11.0



D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:08:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 45711

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0



D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: _____

13.0



D35671

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: _____

14.0



AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH: _____

15.0



D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: _____

16.0



MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: _____

17.0



D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: _____

18.0



D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:08:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 45711

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0



AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: _____

20.0



AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: _____

21.0



MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: _____

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

this step seperates hardware, previous steps is for body & floor*

23.0



MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

24.0



AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: _____

25.0



NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:08:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 45711

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0



MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: _____

27.0



D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: _____

28.0



D35671

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: _____

29.0



D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: _____

30.0



D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: _____

31.0



D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: _____

32.0



MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:08:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 45711

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0



AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: _____

34.0



MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: _____

35.0



D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: _____

36.0



D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: _____

37.0



D2228

Bracket Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: _____

38.0



AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: _____

39.0



AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 45711

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

✓ MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: _____

41.0

✓ D35571

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: _____

42.0

✓ AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

43.0

✓ AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

44.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled glass fibres 10% to weight

A/R Hysol batch: _____ expire date: _____

A/R Milled fibres batch: _____

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:08:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 45711

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

46.0



HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: _____

47.0



QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

48.0



K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

49.0



D350600449

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH RELOCATION KIT

50.0



D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label

51.0



D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: _____

52.0



D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 45711

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0



D35527

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: _____

54.0



D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: _____

55.0



AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: _____

56.0



D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: _____

57.0



QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

58.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: _____

PPP Rev: _____

59.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

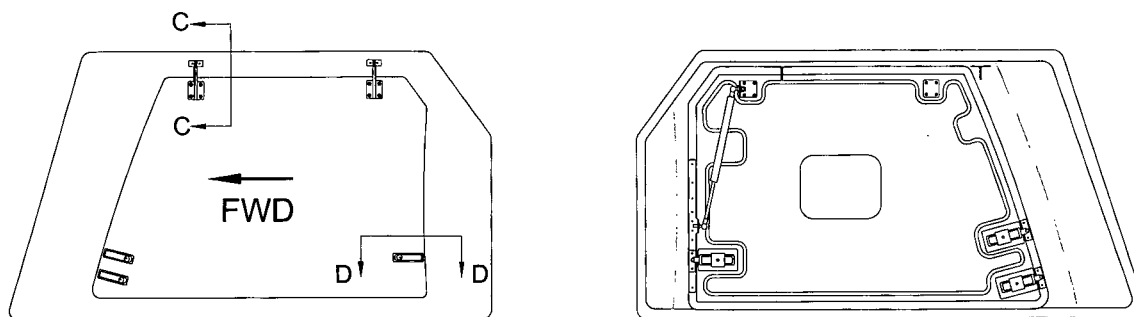


FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)

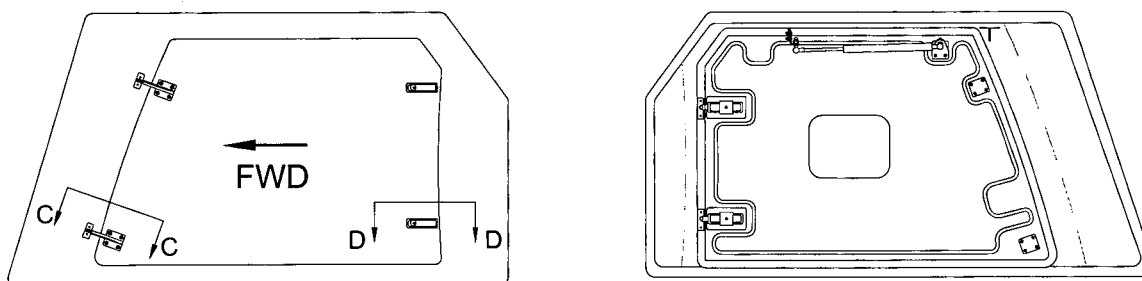
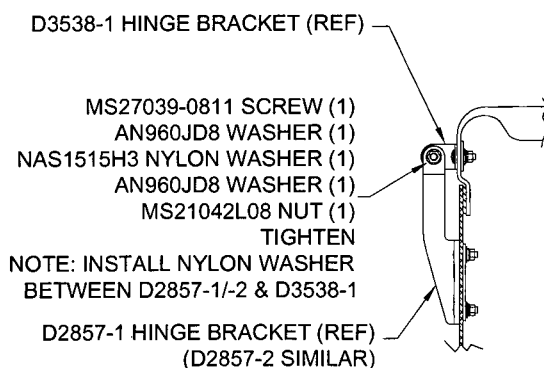
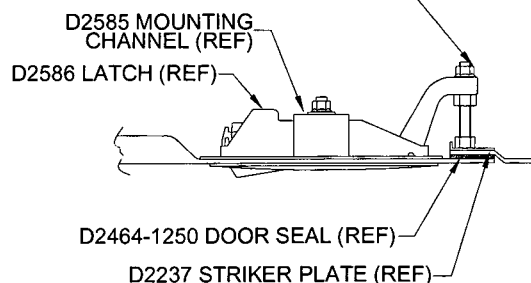


FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



ADJUST SCREW TO ENSURE
COMPRESSION OF DOOR SEAL
AND LOCK IN POSITION WITH NUT



SECTION 'C-C' HINGE
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)

SECTION 'D-D' LATCH

- 3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:
- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
 - If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
 - Re-install the belly panel per the Aircraft Maintenance Manual.

- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).

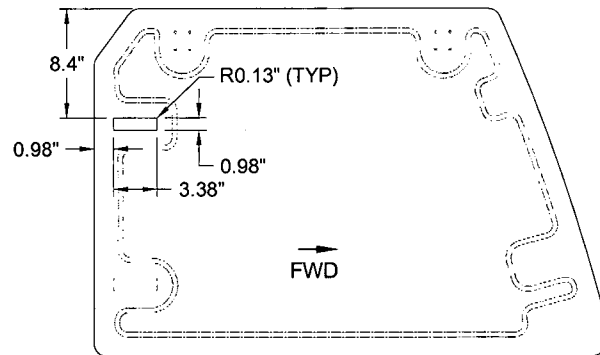


FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -041/-043/-141/-143 KITS)

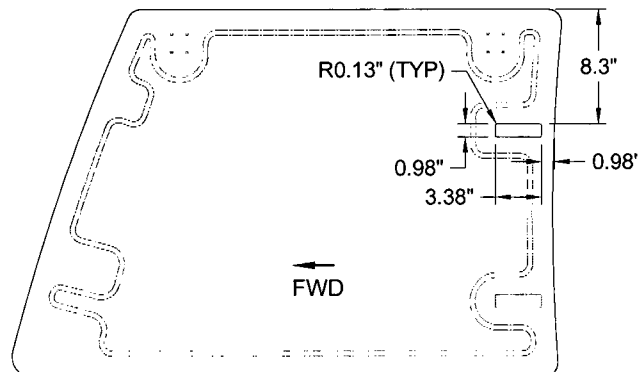


FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -042/-142 KITS)

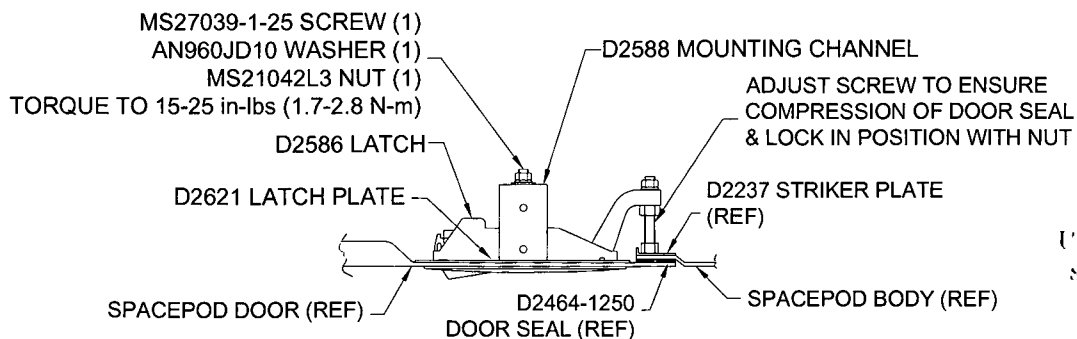


FIGURE 14(c). LATCH INSTALLATION
(SHOWN WITH DOOR INSTALLED ON POD)

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N 45711

- 3.4.7 Position the D2857-1/-2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.

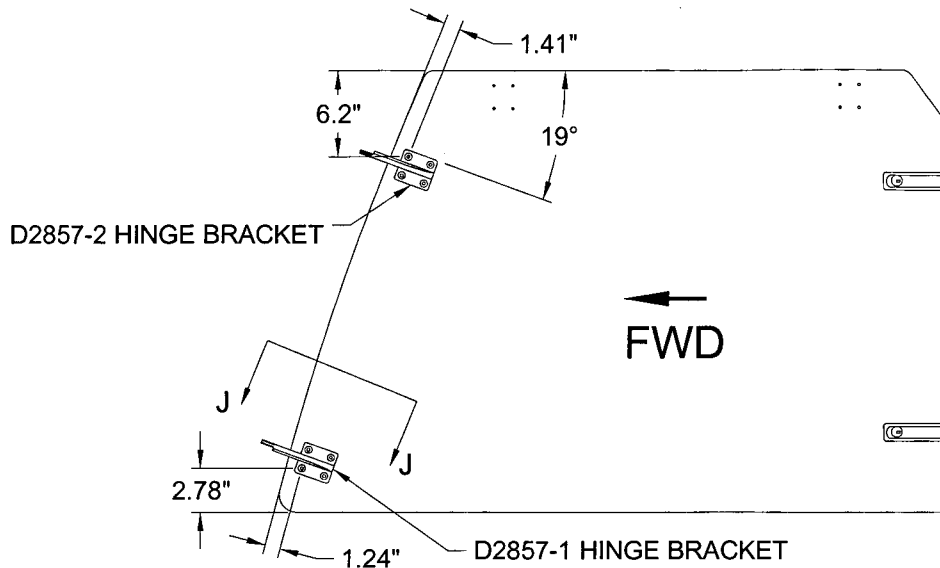


FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR

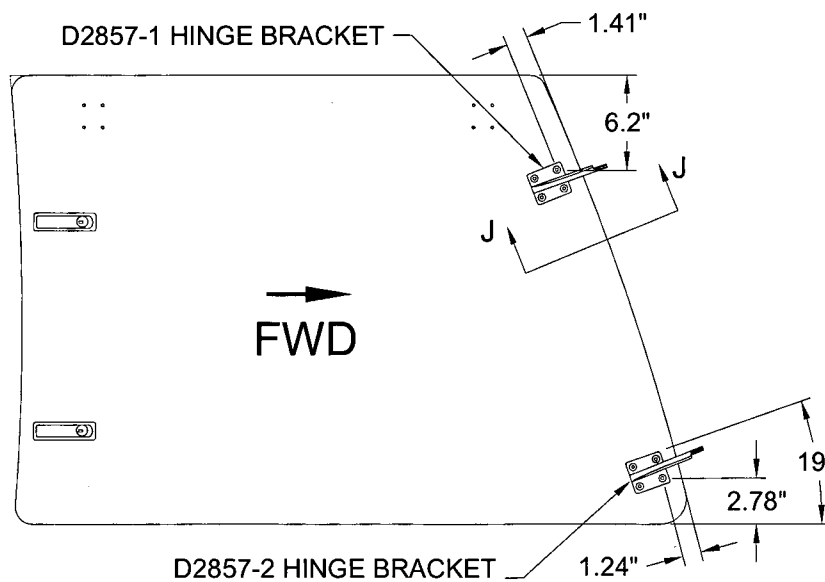
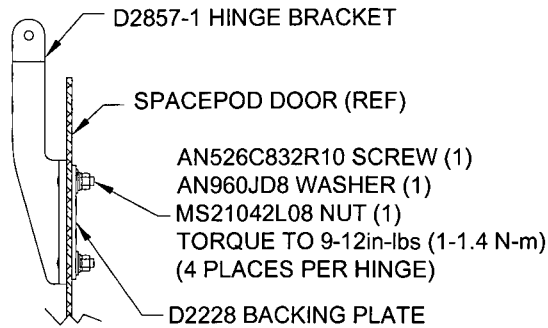


FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR



SECTION 'J-J' HINGE BRACKET INSTALLATION
 (D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.

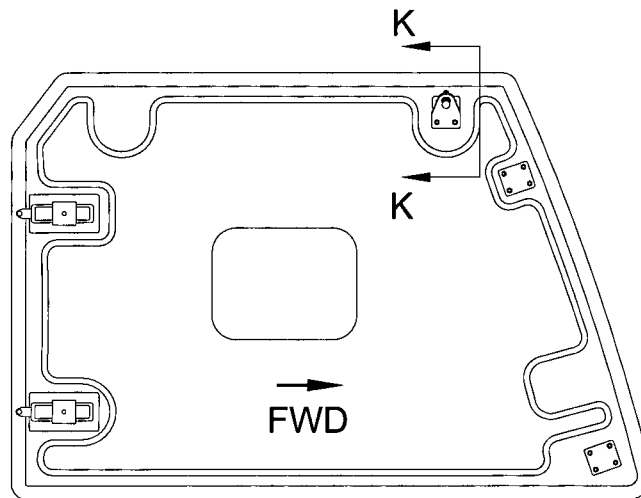
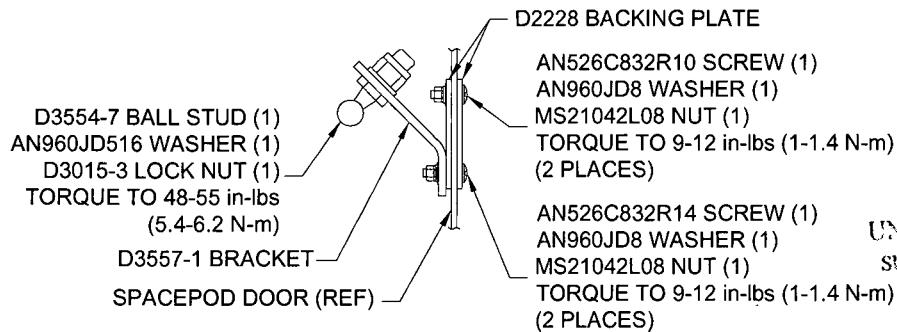


FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR
 (INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



SECTION 'K-K'

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- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
 - Remove the door and drill $\varnothing 0.375$ " holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the **Spacepod™** door and hinges and transfer drill the $\varnothing 0.172$ " D3538-1 hinge bracket mounting holes to the pod.
 - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).

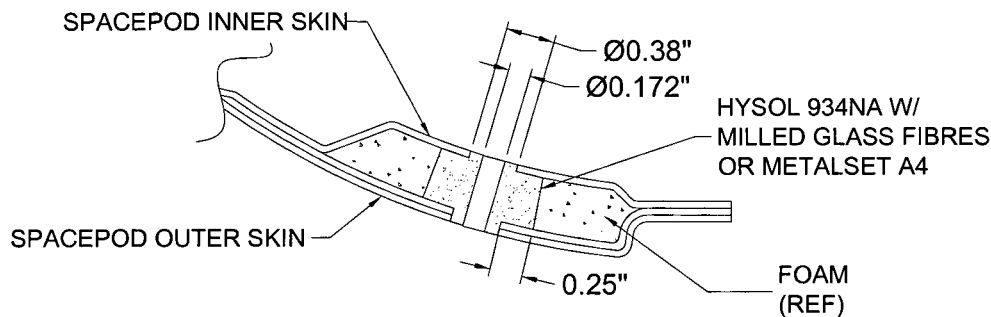


FIGURE 17(a). COMPOSITE MODIFICATION

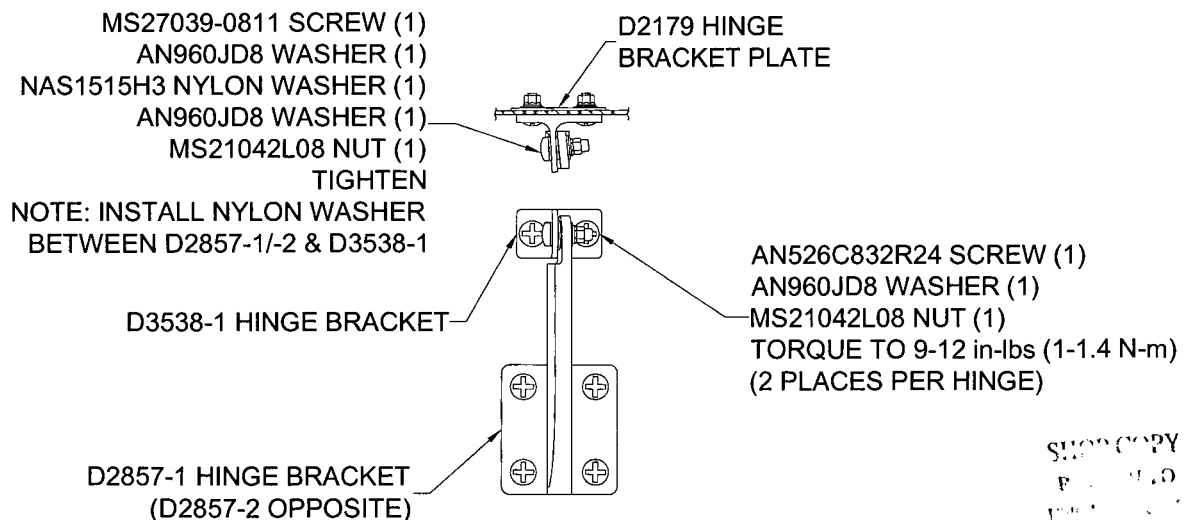


FIGURE 17(b). HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 OPPOSITE)

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